



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

649.5310

Job Sheet 215349



Part No: 649.5310

Job Qty: 8 pcs

Part Name: Lower Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/20

Job Tracking No:

Due Date: 12/15/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP REV. A NEW ISSUE JFS 13/09/27 VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	8 pcs	12/14/20	0.00	7.47		Bandsaw - 1	<i>J</i>
110	HAAS 4 Axis - B4B	8 pcs	12/15/20	1.00	7.47		HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	<i>ALA</i>
							HAAS - 4 - B4B	
120	QC 2	8 pcs	12/15/20	0.00	0.00		QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.ca
www.dartaerospace.com

Container No: S314872



Part: 649.5310

Job No: 215349

Serial No/Batch: S314872

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Plex 11/12/20 8:10 AM Dart.lajeunesse.marie

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	ALA
				QC 2 - 83	
130	QC 8	8 pcs	12/15/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Outsource - 4 - Anodize	8 pcs	12/15/20		ATG001-VC
150	Packaging 2-1 - Receive - B4B	8 pcs	12/15/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B

20/11/22

20/11/22

NOV 2 2020

DEC 2 3 2020

				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155 QC 6	8 pcs	12/15/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				QC 6 - 82	
180 Packaging 3-1 - Stock - B4B	8 pcs	12/15/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

DAS
32
9-89
DEC 23 2020

DAS
23
9-89
DEC 23 2020

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	8 pcs	12/15/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 100 - (Bandsaw)Cut Blank at 18.000" *** ONE BLANK MAKES TWO PARTS***
 Descriptions: 110 - 1-Machine per folio FB213 DWG REV: C FOLIO REV: AA 2- deburr and break all sharp edges
 120 - (QC2- Inspect parts off machine FAI/FAIB)QC2- Inspect parts off machine FAI/FAIB
 130 - (QC8- Inspect parts - second check)QC8- Inspect parts - second check
 140 - Outsource process-Anodize per QSI017 4.1.10.1) Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to
 ATG : _____ 1- Black Anodize as per Dwg 649.5300 2- PRIME AS PER DWG, SEE NOTE #2 Certification of
 Conformity is required
 150 - (Receive & Inspect for Damage & Mat'l Certs)Receive & Inspect for Damage & Mat'l Certs
 155 - QC6- All purchased or subcontracted products
 180 - I(Identify as per dwg & Stock Location: _____)Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER
 APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6B0.375X6.000	7075-T6 Plate 0.375" X 6.000" see mat'l M7075T6S 0.375" x 6.000"	6 ft (.75 ea)	100-Bandsaw - 1	5312516

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6B0.375X6.000	6	0	0

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD	Work Order: 215349
Description: Lower Deflector	Part Number: 649.5310
Inspection Dwg: 649.5300 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	.373			VERV	ALA-01
0.360	+/-0.010	.362			"	"
0.100 x 45°	+/-0.010 x 0.5°	.105 x 45°			"	"
0.358	+0.002/-0.000	.3595			MIC	ALA-04
0.668	+/-0.010	.669			VERV	ALA-01
Ø0.177	+0.005/-0.001	.177			GP	REF.
Ø0.250	+0.005/-0.001	.250			"	"
Ø0.194	+0.005/-0.001	.194			"	"
6.265	±.005	6.264			HG	31006
.374	±.005	.374			"	"
.651	±.005	.651			"	"
.764	±.005	.765			"	"
4.307	±.005	4.305			"	"
5.962	±.005	5.962			"	"
13.104	±.005	13.105			"	"
.878	±.005	.878			"	"
2.643	±.005	2.643			"	"
8.157	±.005	8.157			"	"
8.010	±.005	8.010			"	"
10.120	±.005	10.120			"	"
12.230	±.005	12.230			"	"
36.2°	±.5°	36.2°			AG	REF.
28.5°	±.5°	28.4°			"	"
57.4°	±.5°	57.4°			"	"
302.6°	±.5°	302.6°			"	"
218°	±.5°	218°			"	"

Measured by: ALA	Audited by: [Signature]	Preliminary Approval:
Date: 20/11/22	Date: 20/11/22	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.09	New Issue	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:		QTY Affected :		MRB (QSI042)
Description Work Order Deviation			Disposition		Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			



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K6A 1K7
Canada

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PURCHASE ORDER

POHB047725



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047725

PO Date: 11/24/20

Due Date: 12/2/20

Purchase Order

Revision:

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	214445	C3-11-1	C3-11-1 Rev 9	Side Plate - Solenoid C3-Hook Outsource process- Anodize per QSI017 4.1.10.1 - Issue P/O to Groupe Altech : -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed XIS		12/2/20	15 pcs DEC 02 2020	0 pcs	15 pcs	\$6.28/pcs	\$94.20
Line Item Note: rush												
	213661				Firmed XIS		12/2/20	8 pcs DEC 02 2020	0 pcs	8 pcs	\$6.28/pcs	\$50.24
Sub Total:								23	0	23		\$144.44
2	214450	C3-2-1	C3-2-1 Rev 11	Side Plate C-3 Hook Outsource process- Anodize per QSI017 4.1.10.1 - Issue P/O to GROUPE ALTECH: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed XIS		12/2/20	15 pcs DEC 02 2020	0 pcs	15 pcs	\$6.28/pcs	\$94.20

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PURCHASE ORDER POHB047725



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Line Item Note: RUSH												
214179					Firmed	-	12/2/20	5 pcs	0 pcs	5 pcs	\$6.28/pcs	\$31.40
Sub Total:								20	0	20		\$125.60

3	215532	D5771-13	D5771 REV.A	Crescent Bushing -Issue P/O; ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2 -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/2/20	12 pcs	0 pcs	12 pcs	\$1.78/pcs	\$21.36
Line Item Note: RUSH												

4	213283	DT10750-1	DT10750 A	Side Plate -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625 TYPE 2 CLASS 1 -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/2/20	2 pcs	0 pcs	2 pcs	\$2.28/pcs	\$4.56
Line Item Note: RUSH												

5	213284	DT10750-3	DT10750 A	Top Plate -Issue P/O; ANODIZE COLOR CLEAR, PER IAW MIL-A-8625 TYPE 2 CLASS 1 - Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/2/20	2 pcs	0 pcs	2 pcs	\$2.28/pcs	\$4.56
Line Item Note: RUSH												

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PURCHASE ORDER POHB047725



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	214135	647.1511	647.1500 E	Lower Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize Color Black, Prime as per Dwg 647.1500	Firmed X20	-	12/18/20	20 pcs	0 pcs	20 pcs	\$11.93/pcs	\$238.60
7	214166	647.1510	647.1500 Rev E	Upper Deflector : Various STC's Outsource process-Anodize per QSI017 4.1.10.1) - Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.1500	Firmed	-	12/18/20	20 pcs	0 pcs	20 pcs	\$21.43/pcs	\$428.60
8	214230	647.7811	647.7800 Rev A	Bracket B : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed X20	-	12/18/20	20 pcs	0 pcs	20 pcs	\$15.28/pcs	\$305.60
9	214430	647.7610	647.7600	Upper Deflector : Various STC's Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 1- Black Anodize as per Dwg 647.7600 2- PRIME AS PER DWG, SEE NOTE #7 (**DISREGARD AFTER ASSEMBLY***) Certification of Conformity is required	Firmed X20	-	12/18/20	20 pcs	0 pcs	20 pcs	\$12.83/pcs	\$256.60

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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB047725



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	215349	649.5310	649.5300	Lower Deflector : Various STC's Outsource process- Anodize per QSI017 4.1.10.1) Outsource process- Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 1- Black Anodize as per Dwg 649.5300 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed <i>LE</i>	-	12/18/20	8 pcs	0 pcs	8 pcs	\$12.23/pcs	\$97.84
Grand Total:												\$1,627.76

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 921263

Date: 22-Dec-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 649.5310 Rev: C Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: _____ Expiry Date: _____ Job: 28568 Line: 10 PO: POHB047725		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>DEC 22 2020</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

RECEIVED
DEC 22 2020
DART AEROSPACE LTD.

Made in Canada.